

Work Order ID 86041

June-19-12 4:09:26 PM

86041

Page 1

Item ID: D3809-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Sliding Block

Start Date: 19/06/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: *MLJ*

Date: *12/06/20* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3809

Rev A

100

0.00

100

SHEAR

Shear

Memo

0.00

OK 12/06/23

8

OK

Shear

Cut Blanks 1.850" long

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

OK 12/06/23

8

OK

HAAS CNC vertical machine #1

1- Mill as per Folio FA770 Rev: *AA* & Dwg D3809 Rev: *A* 2-Deburr
per dwg D3809

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

OK 12/06/23

8

OK

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

SL 12-06-25

130

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: ST 65

0.00

140

Packaging

Memo

0.00

Packaging

8x

SP 12-6-25

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/6/26 JG

MR 12-06-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 86041

86041

Parent Item: D3809-1

D3809-1

Parent Item Name: Sliding Block

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A NEW ISSUE 08-08-01 JLM

Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDEL RINB0.250X01.0 00		Purchased	No			100	f	11.0000	0.15	1.263158			

MDFI RINB0 250X01 000

**

Delrin Bar 0.25" x 1.0"

Location

Loc Qty

Loc Code

MAT055

11

110877

3.2

117985

7.8

1.27 mk 12/06/23

W/O:		WORK ORDER CHANGES					
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Dart Aerospace Ltd

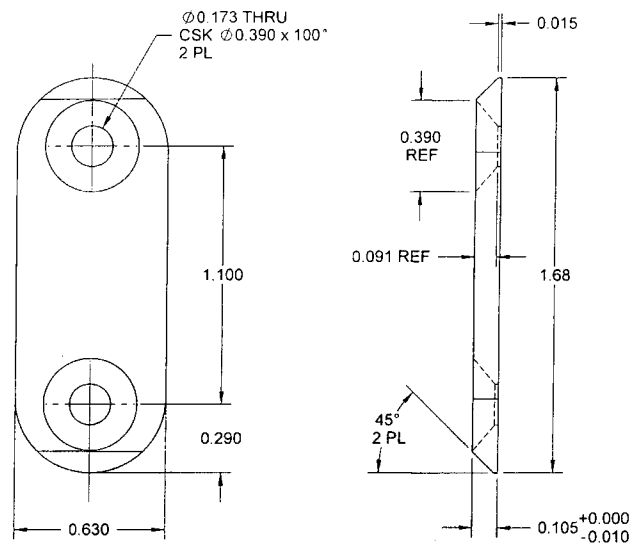
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D3809-1 SLIDING BLOCK
SCALE 2X

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86041 *MLJ*
12/06/20

RELEASED
08-07-24

NOTES:

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL SHEET OR BAR (REF. DART SPEC. M-DELRIN-S OR M-DELRIN-B)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.004 lbs

A	NEW ISSUE	RF	08.07.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>RF</i>	D3809	SHEET 1 OF 1
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	SLIDING BLOCK	NTS
DATE	08.07.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. NO IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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